

# Work Order ID 53457

November 6, 2009 8:21:03 AM



Page 1

Item ID: D3942-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Angle

Start Date: 05/11/2009 Start Qty: 30.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

*BP*

Date:

*09-11-5*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3942-1

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

*18 9-11-11*

*09/11/16*



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*18 9-11-11*

**Work Order ID 53457**

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Page 2

Item ID: D3942-1

Revision ID: A

Item Name: Angle

Start Date: 05/11/2009 Start Qty: 30.00

Required Date: 13/11/2009 Req'd Qty: 30.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

2) 8/2/11/12

counted  
50

130



Brake NC

Brake NC

Memo

1- Bend as per dwg D3942

0.00

0.00

2) 8/2/11/17

50

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2) 8/2/11/12

counted  
50

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Item ID: D3942-1

Revision ID: A

Item Name: Angle

Start Date: 05/11/2009 Start Qty: 30.00

Required Date: 13/11/2009 Req'd Qty: 30.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00  0.00							9/11/17 (500) SP
160  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							09/11/18 JF JF 09-11-18

# Picklist Print

November 6, 2009 8:21:09 AM

Page 1

Work Order ID: 53457



Parent Item: D3942-1RevA



Parent Item Name: Angle



Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S18GA 		Purchased	No			100	sf	275.5564	0.4737	1,		
304/316 .050 Sheet												

B 941-11

Warehouse                      Loc Qty                      Loc Code

Location

Main Warehouse

MAT

275.5564053

108156

0.98526316

111743

23.7174

112178

24.2642421

112885

98.5895

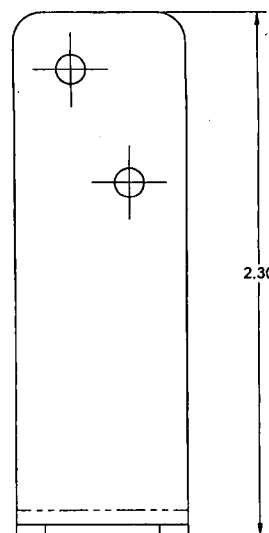
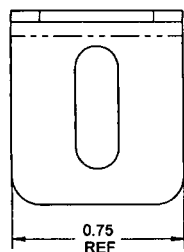
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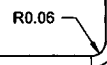
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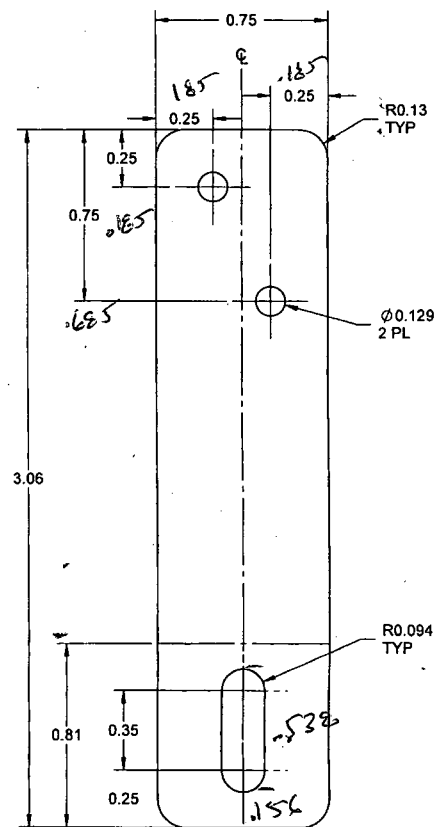




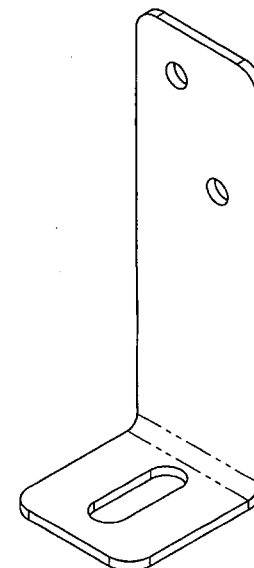
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REF



**D3942-1 ANGLE**  
MADE FROM D3942-1F



**D3942-1F FLAT PATTERN**



**RELEASED**  
09/06/02

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524  
18 GAUGE (0.050 THICK)  
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3942-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

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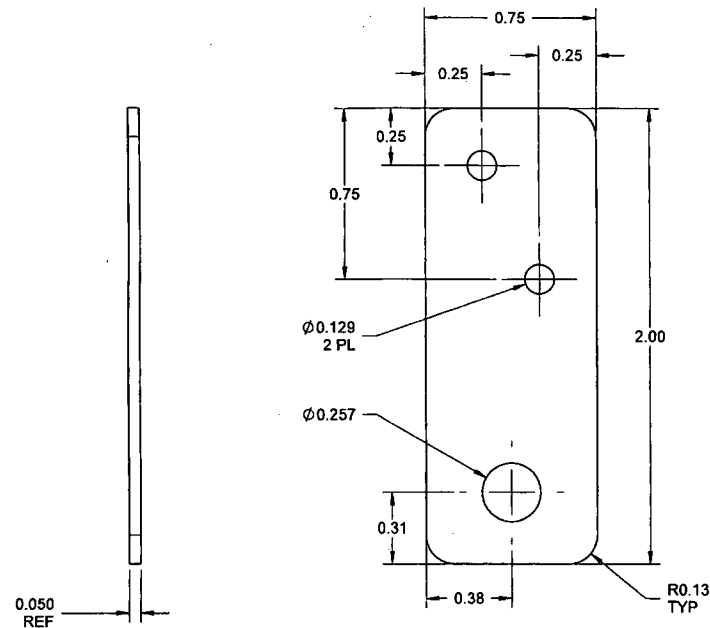
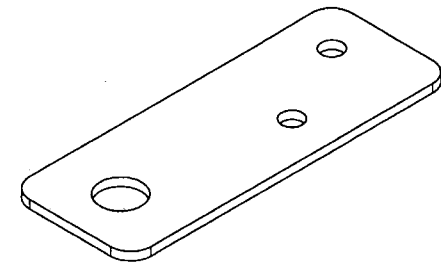
WITHOUT NOTICE

WORK ORDER

NO 53457

09-11-5

A	NEW ISSUE			09.05.06
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
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**D3942-3 CLIP**

**RELEASED**  
9/16/03

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524  
18 GAUGE (0.050 THICK)  
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3942-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

u/o 53457

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DRAWN	95	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
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